

1. A dosage form comprising:

- (a) an outer wall defining an interior compartment;
- (b) a therapeutic agent within the interior compartment;
- (c) at least one laser formed exit orifice in the outer wall; and
- (d) a barrier layer disposed between the outer wall and the interior compartment in at least

a region corresponding to the at least one exit orifice wherein the barrier layer comprises a material that allows the barrier layer to remain intact during formation of the at least one laser formed exit orifice.

2. The dosage form of claim 1, wherein the outer wall comprises a semipermeable material.

3. The dosage form of claim 1, wherein the barrier layer surrounds the interior compartment.

4. The dosage form of claim 1, wherein the barrier layer is a contiguous film.

5. The dosage form of claim 1, wherein the barrier layer is a non-contiguous porous film.

6. The dosage form of claim 1, wherein the interior compartment contains a therapeutic agent in a solid state.

7. The dosage form of claim 1, wherein the interior compartment contains a therapeutic agent in a liquid state within a water-soluble capsule.

8. The dosage form of claim 7, wherein the barrier layer is disposed between the water-soluble capsule and the outer wall.

9. The dosage form of claim 7, wherein the barrier layer is coextensive with the water-soluble capsule.

13. The dosage form of claim 1, wherein the material comprising the barrier layer is a material capable of reflecting laser energy under from a selected laser type and from selected laser operating conditions used to form the at least one laser formed exit orifice.

14. The dosage form of claim 13, wherein the selected laser is a carbon dioxide laser and the material comprising the barrier layer is selected from the group consisting of carbon black, powdered stainless steel, powdered nickel, powdered iron, hydrous magnesium silicate (talc), powdered glass, titanium dioxide, magnesium aluminum silicate, aluminum silicate, aluminum oxide and metallic chips or flakes.

15. The dosage form of claim 1, wherein the material included in the barrier layer is a material capable of transmitting laser energy from a selected laser type and selected laser operating conditions used to form the at least one laser formed exit orifice.